

Work Order ID 78206

78206

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January-02-12 10:14:08 AM

Item ID: D3463-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step Weldment Assembly
 Start Date: 02/01/2012 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 31/01/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: M.C.J Date: 12/01/02 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3463	Rev B								
100	Large Fab	0.00							
100									
Large Fab	Memo	0.00							
Large Fab	Weld assembly as per dwg D3463 using DT8875								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									

12-1-31 (4)

CP 12-02-01

4/1 Ø

8/2/02/11

(4)
-04/1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Start Date: 02/01/2012 **Start Qty:** 4.00

4

Customer:

Required Date: 31/01/2012 **Req'd Qty:** 4.00

4

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00
-----	---	------

130

Powdercoat

Powder Coating

Memo

0.00

1- Mask areas indicated on dwg D3463, (holes, threads)

START TIME:

OVEN TEMPERATURE: _____

FINISH TIME:

140	Wing Walk as per dwg QSI005 4.4 Batch	0.00
-----	---------------------------------------	------

140

HandFinish

Hand Finishing

Memo

0.00

150	QC3- Inspect Part Finish	0.00
-----	--------------------------	------

150

QC

Quality Control

Memo

0.00

4X ~~Ø~~ M-L 12/02/06

4 BL 12-2-7

4x cl il 12/02/07
counted

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Accept

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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <i>GA</i>	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

12/2/12
GA

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Picklist Print

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Work Order ID: 78206

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Parent Item: D3463-041

D3463-041

Parent Item Name: Step Weldment Assembly

Start Date: 02/01/2012

Required Date: 31/01/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV. A 05.11.18 new issue EC IPP revB: replace pressure
with wing walk DD 10.01.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
238-806		Purchased	No			100	Each	64.0000	2	8			
238-806									**				
SS DOWEL PIN 1" LONG													
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					ST399			64					
					117606			64					
D3453-3		Manufactured	No			100	Each	12.0000	1	4			
D3453-3									**				
Clevis													
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					WA022			12					
					71900			4					
					73622			8					
D3453-5		Manufactured	No			100	Each	11.0000	1	4			
D3453-5									**				
Plug													
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					WA022			11					
					59204			1					
					73623			10					
D3463-1		Manufactured	No			100	Each	4.0000	1	4			
D3463-1									**				
Arm													
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					WA030			4					
					70855			4					
					77693 x 4								

EL 12-7-30

EL 12-7-30

EL 12-1-30

EL 12-1-30

Dart Aerospace Ltd

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: D3463-041

D3463-041

Parent Item Name: Step Weldment Assembly

Start Date: 02/01/2012

Required Date: 31/01/2012

Start Qty: 4.00

Required Qty: 4.00

D3463-3	Manufactured	No	100	Each	12.0000	1	4	
D3463-3								
Step								
						**		<u>A 12-1-31</u>

			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			WA023	12				
			<u>46269</u>	12				<u>4</u>
D3463-5	Manufactured	No	100	Each	21.0000	2	8	
D3463-5								
End Cap								
						**		<u>B 12-1-30</u>

			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			WA023	21				
			<u>70819</u>	21				<u>8</u>
D3463-7	Manufactured	No	100	Each	11.0000	1	4	
D3463-7								
Drag Arm								
						**		<u>A 12-1-30</u>

			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			WA	10				
			WA025	1				
			<u>70857</u>	1				
			<u>73624</u>	10				<u>4</u>

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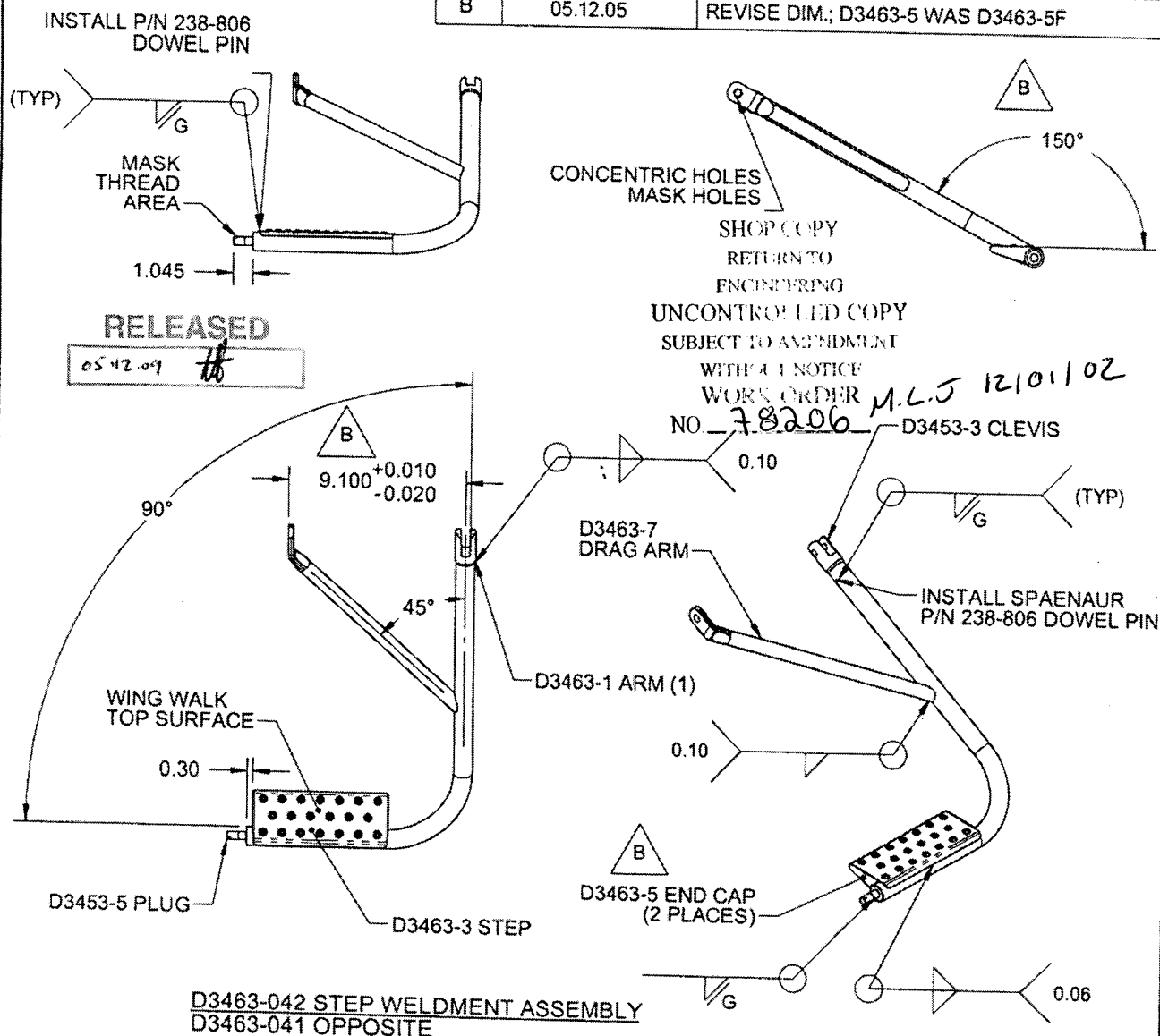
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3463	REV. B SHEET 1 OF 4
DATE 05.12.05	TITLE STEP WELDMENT SCALE 1:8		
A	05.09.20	NEW ISSUE	
B	05.12.05	REVISE DIM.; D3463-5 WAS D3463-5F	



NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

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Dart Aerospace Ltd

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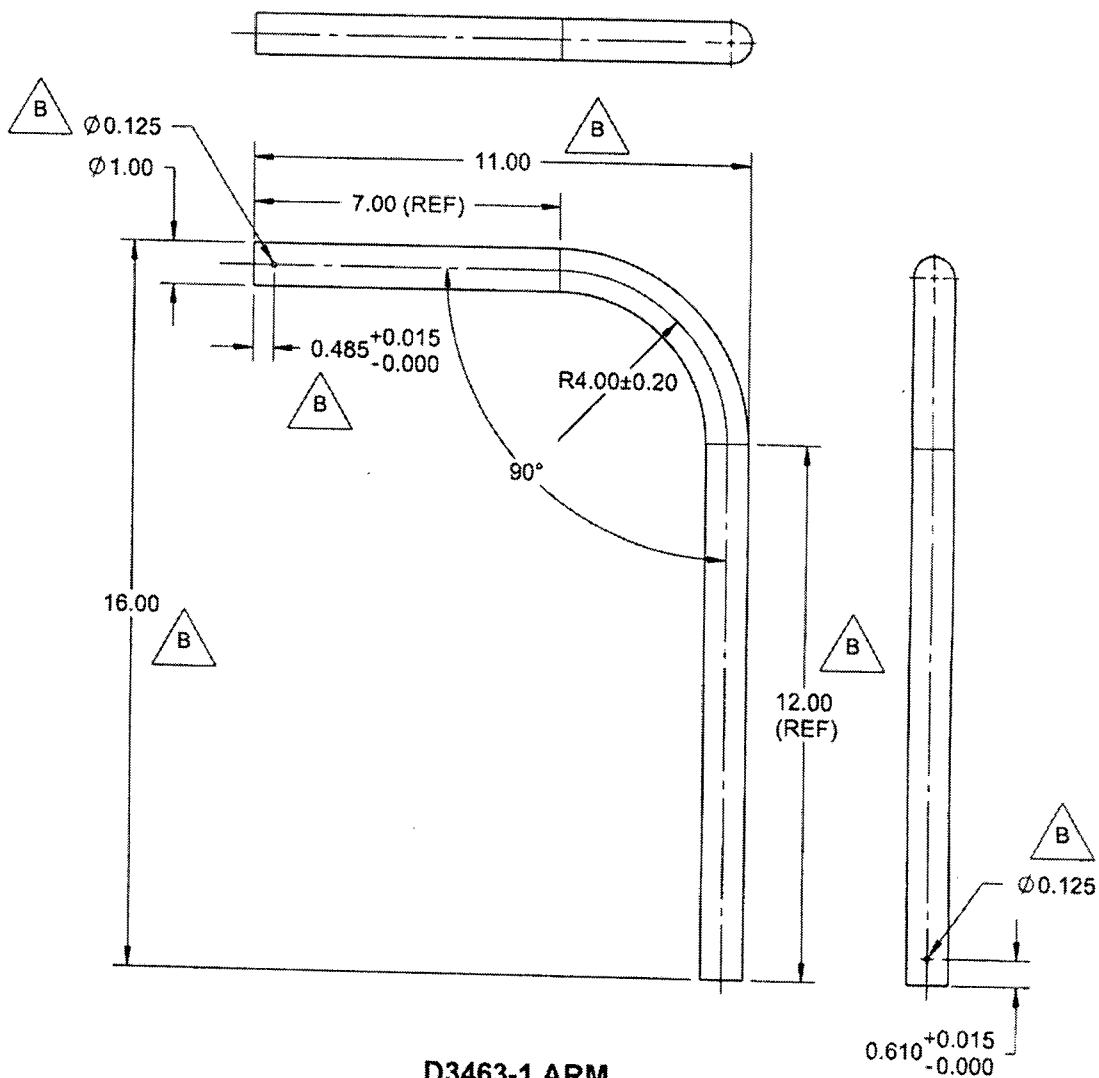
NOTE: Date & initial all entries



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3463	REV. B
DATE 05.12.05	TITLE STEP WELDMENT		SHEET 2 OF 4 SCALE 1:4

RELEASED

05.12.09 [Signature]



D3463-1 ARM

NOTES:

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR1.000W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

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